

**Work Order ID 85822****\*85822\***

Page 1

June-15-12 1:32:04 PM

Item ID: D206-642-541

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 15/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*Date: *12/06/15* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3274

D

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-541

CHG003

*N/A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85822****\*85822\***

Page 2

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**\*N900040100\***Setup Start **\*NS1\***

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Stop **\*NS2\***

Start Date: 15/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

\*\*\*VERIFY AND INSPECT THE MATERIAL PRIOR TO USE\*\*\*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M120164

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.  
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe  
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 12-7-12

3 BE12-07-12

DE 12/07/12

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Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

**\*114\***

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

**\*116\***

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

1 *JB* 12-7-16

W/O:		WORK ORDER CHANGES					
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Process Plan:

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QC:

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Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC7-Inspect Chemical Conversion Coat 0.00

**\*130\***

QC Memo 0.00

Quality Control

*DP 12-7-17*

150 Skidtubes 0.00

**\*150\***

Skidtubes Memo 0.00

Skidtubes 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/RSikaflex-291 *12-4-12 M 122 130*

Sikaflex expire date: *13-4-12*

Start: *12/07/17* Time: *9:00*

Finish: *12/07/17* Time: *1:00*

(Adhere for 12 hours)

*cc 12/07/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Skidtubes

0.00

**\*170\***

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding



12-7-18

SAD 12-07-18

DE 12/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00				1		12/07/25	DAS 18
Quality Control									
190		0.00							
<b>*190*</b>									
Skidtubes									
Skidtubes	Memo	0.00							
Skidtubes	1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>M122324</u>								
	3-Grind cross bolt welds flush as per Dwg D3274.								
	4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.								

BE 12/07/25  
CF 12-7-26

DP 12-7-26

# Dart Aerospace Ltd

W/O: 85822		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ06-642-541 PAR #: \_\_\_\_\_ Fault Category: landing gear/skid tubes NCR: Yes No DQA: AWZ Date: 12/08/17  
 Resolution: Acceptable Disposition: Acceptable QA: N/C Closed: 180 Date: 12/08/20

NCR: 12-1698		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/27	#190.4	Found at inspection that the holes are counter bored @ 0.825" to 0.830" should be @ 0.75" ± 0.030 R.C. counter bore tool was	DAS 12 9-89 12/7/17	Acceptable per Email from Chris P to DS on July 23rd, 2012. Email attached.	12-7-27	DAS 16 9-89 12/7/30	DAS 16 9-89 12/9/16	DAS 16 9-89 12/07/27
		set incorrectly. operator error LON						

NOTE: Date & initial all entries

## Linda Lacelle

---

**From:** Chris Provencal <cprovencal@dartaero.com>  
**Sent:** July-27-12 11:15 AM  
**To:** David Shepherd  
**Cc:** psmith@dartaero.com; 'L Lacelle'; 'Isam El-Kassis'; 'Eric Downing'; Mike Petsche  
**Subject:** RE: D206 skids

David,

The affected tubes are several float (-541) and regular tubes (-351). The float holes aren't counterbored and are unaffected. As the crossbolt spacers are not loaded except in bearing by the bushings, the additional length of the counterbore would have no effect on the strength of the crossbolt spacer from regular loading conditions. There would be a small reduction in buckling strength from sideways crushing loads, which doesn't represent a critical loading condition per the FAR requirements.

I will accept these tubes based on that rational. This email is an FYI in case you have an objection.

-Chris

---

**From:** Eric Downing [<mailto:edownring@dartaero.com>]  
**Sent:** Friday, July 27, 2012 8:34 AM  
**To:** 'Provencal, Chris'  
**Cc:** psmith@dartaero.com; 'L Lacelle'; Isam El-Kassis  
**Subject:** D206 skids  
**Importance:** High

Good morning Chris

I need to see you as soon as you read this message I have found the counter bore depth on QTYX9 D206 skids are too deep. I am measuring 0.820"-0.830" and it should be at 0.75+/-0.030". I have 6 in progress and 3 already painted and assembled. What happened was that I had inspected some 206 skids and found that the counter bore was correct but I didn't know that they had changed the counter bore part way through the day and was not set up correctly so I had assumed that they were still the same depth and when I measured the first one today like I do always the depth was not correct at all.

I need to know if this will be acceptable or that we need to rework all the skids.

Thanks  
Eric Downing  
QC Corrdinator  
Dart Aerospace LTD

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

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June-15-12 1:32:04 PM

**\*85822\***

Page 7

Item ID: D206-642-541

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

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Item Name: Replacement Skidtube

Start Date: 15/06/2012 Start Qty: 1.00

**\*1\***

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Required Date: 29/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

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Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							(DAS 16 8-83) 12/6/12
210 <b>*210*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							(DAS 15 8-83) 12/6/12
220 <b>*220*</b> HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00  0.00							1 26 12-7-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Sequence ID/  
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Operation  
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Set Up/  
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Plan  
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Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*230\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Quality Control

Memo

0.00

250

HandFinishing

0.00

**\*250\***

HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 114596

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 123130

Sikaflex expire date: 14/03

1X ✓ 12/07/30

1 & (2P) 12/07/31

1 & (2P) 12/07/31

mi21871

3'-45  
3200 F  
4'-15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

**\*260\***

QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

270

0.00

**\*270\***

HandFinish

HAND FINISHING RESOURCE #1

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R Sikaflex-291 122130

Sikaflex expire date: 14/03

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 01/12

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 122130

Sikaflex expire date: 14/03

Procyon 114 596

DAS  
16  
12/4/31

1 ~~2~~ 5P 12/07/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85822**

June-15-12 1:32:04 PM

**\*85822\***

Page 10

Item ID: D206-642-541

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 15/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC5- Inspect part completeness to step on W/O

0.00

**\*280\***

QC

Memo

0.00

Quality Control

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*290\***

Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

**\*300\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:32:07 PM

Page 1

Work Order ID: 85822

**\*85822\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM  
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM  
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD  
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC  
 IPP Rev:F 08-06-02 add comment DD verified by:EC  
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-1-190

Manufactured

No

110

Each

106.0000

1

1

**\*D2600-1-190\***

Extrusion Round 3" 206

\*\*

*DP 12-7-12*

### Location

### Loc Qty

### Loc Code

HALL

45

69622

45

LG

61

76912

61

D3285-1

Manufactured

No

110

Each

42.0000

1

1

**\*D3285-1\***

Cap

\*\*

*BE 12-07-12*

### Location

### Loc Qty

### Loc Code

LG002

42

52511

1

52647

41

D3282-041

Manufactured

No

150

Each

9.0000

1

1

**\*D3282-041\***

Float Web (206L/407)

\*\*

*BE 12/07/12*

### Location

### Loc Qty

### Loc Code

LG

9

82651

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-15-12 1:32:08 PM

Page 2

Work Order ID: 85822

\*85822\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

181.0000

12

12

\*D2649\*

Cross Bolt Spacer

\*\*

BE12/07/25  
B 869/2 \*12

Location

Loc Qty

Loc Code

LG

38

77574

2

79502

8

79503

17

79564

4

79565

7

LG001

143

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

16

D3275-1

Manufactured No

190

Each

105.0000

12

12

\*D3275-1\*

Crossbolt Spacer

\*\*

BE12/07/25

Location

Loc Qty

Loc Code

LG

40

85418

40

LG002

65

66930

1

83264

64

12

June-15-12 1:32:08 PM

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Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:32:08 PM

Page 3

Work Order ID: 85822

\*85822\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,248.000

2

2

\*CR3212-4-03\*

Cherry Rivet

\*\*

2

DP

12/07/31

## Location

## Loc Qty

## Loc Code

FP002

340

114859 ✓

340

ST331

908

110139

2

119017

906

D3415-041

Manufactured

No

250

Each

31.0000

1

1

\*D3415-041\*

Nut Plate

\*\*

1

DP

12/07/31

## Location

## Loc Qty

## Loc Code

ST042

31

82151 ✓

31

CCR264SS3-3

Purchased

No

250

Each

320.0000

2

2

\*CCR264SS3-3\*

Cherry Rivet

\*\*

2

DP

12/07/31

## Location

## Loc Qty

## Loc Code

ST331

320

113973

2

117849 ✓

77

119017

241

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:32:08 PM

Page 4

Work Order ID: 85822

**\*85822\***

Parent Item: D206-642-541

**\*D206-642-541\***

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

1,737.000

78

78

**\*AI S4-1032-130\***

Insert

\*\*

79

DP

12/07/31

## Location

## Loc Qty

## Loc Code

ST280

122474 ✓

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

1488

121269

1488

D3536-15

Manufactured

No

270

Each

5.0000

1

1

**\*D3536-15\***

Gasket

\*\*

1

DP

12/07/31

## Location

## Loc Qty

## Loc Code

FP002

85604 ✓

5

73318

4

81343

1

D3536-23

Manufactured

No

270

Each

39.0000

1

1

**\*D3536-23\***

Gasket

\*\*

1

DP

12/07/31

## Location

## Loc Qty

## Loc Code

FP

36

85295

36

FP002

3

74510

1

83377

2

85295 ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:32:08 PM

Page 5

Work Order ID: 85822

\*85822\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-35 Manufactured No 270 Each 15.0000 1 1  
**\*D3536-35\***  
 Gasket \*\* 1 (2P) 12/07/31

Location	Loc Qty	Loc Code
FP002 85605 ✓	15	
81340	4	
82065	11	

D3536-39 Manufactured No 270 Each 9.0000 1 1  
**\*D3536-39\***  
 Gasket \*\* 1 (2P) 12/07/31

Location	Loc Qty	Loc Code
FP 82252 ✓	9	
	9	

D3535-15 Manufactured No 270 Each 21.0000 1 1  
**\*D3535-15\***  
 Wearshoe \*\* 1 (2P) 12/07/31

Location	Loc Qty	Loc Code
FP001	21	
81354	2	
85291 ✓	19	

D3535-35 Manufactured No 270 Each 28.0000 1 1  
**\*D3535-35\***  
 Wearshoe \*\* 1 (2P) 12/07/31

Location	Loc Qty	Loc Code
FP001	28	
67598	1	
70815	1	
78873	13	
79849	1	
83638 ✓	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-15-12 1:32:08 PM

Page 6

Work Order ID: 85822

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

\*85822\*

\*D206-642-541\*

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-39      Manufactured      No      270      Each      21.0000      1      1      \*\*      1      (SP)      12/07/31  
Wearshoe

Location	Loc Qty	Loc Code
FP001	21	
69759	1	
74513	2	
81359 ✓	18	

D3535-23      Manufactured      No      270      Each      8.0000      1      1      \*\*      1      (SP)      12/07/31  
Wearshoe

Location	Loc Qty	Loc Code
FP001 85256 ✓	8	
83375	8	

D3537-3      Manufactured      No      270      Each      4.0000      1      1      \*\*      1      (SP)      12/07/31  
Wearpad

Location	Loc Qty	Loc Code
FP002 85481 ✓	4	
78836	1	
81363	3	

D3537-1      Manufactured      No      270      Each      71.0000      9      9      \*\*      9      (SP)      12/07/31  
Wearpad

Location	Loc Qty	Loc Code
FP002 85458 ✓	71	
81362	6	
83254	1	
83255	3	
83256	55	
84091	6	
86238 ✓		

June-15-12 1:32:08 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:32:08 PM

Page 7

Work Order ID: 85822

\*85822\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L ~~NAS1149C0332~~ Purchased

No

270

Each

21.0000

80

80

\*AN960C10I \*

washer

122063✓

\*\*

80

29

12/07/31

Location

Loc Qty

Loc Code

ST

21

107534

21

AN960C416 ~~NAS1149C0463~~ Purchased

No

270

Each

0.0000

1

1

\*AN960C416\*

washer

119097✓

\*\*

1

29

12/07/31

D3672-1

Manufactured

No

270

Each

1,422.000

2

2

\*D3672-1\*

Phenolic Washer

\*\*

2

29

12/07/31

Location

Loc Qty

Loc Code

ST060

1422

72229

4

76277

13

80369✓

395

83608

500

85222

510

AN3C4A

Purchased

No

270

Each

955.0000

80

80

\*AN3C4A\*

BOLT

\*\*

80

29

12/07/31

Location

Loc Qty

Loc Code

ST350

955

120187

31

120521

28

120769

38

121205

842

121556

16

12151✓

June-15-12 1:32:08 PM

Shop Packet Print

Page 7

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-15-12 1:32:08 PM

Page 8

Work Order ID: 85822

\*85822\*

Parent Item: D206-642-541

\*D206-642-541\*

Parent Item Name: Replacement Skidtube

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

181.0000

1

1

\*AN4C5A\*

BOLT

\*\*

2P

12/07/31

Location

Loc Qty

Loc Code

ST355

181

112243 ✓

135

119017 ~~WAT~~

46

D2646

Manufactured

No

270

Each

54.0000

1

1

\*D2646\*

Aft Cap

\*\*

2P

12/07/31

Location

Loc Qty

Loc Code

FP002

54

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

1

79562

5

81974

32

D3413-1

Manufactured

No

270

Each

55.0000

1

1

\*D3413-1\*

Ring

\*\*

2P

12/07/31

Location

Loc Qty

Loc Code

ST420

4

79233

4

ST464

51

80224

4

83307

27

83867

20

87253 ✓

June-15-12 1:32:08 PM

Shop Packet Print

Page 8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	, MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED  
07.02.12 [Signature]  
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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WITHOUT NOTICE  
WORK ORDER  
12/06/15  
85822M15

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ENGINEERING

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

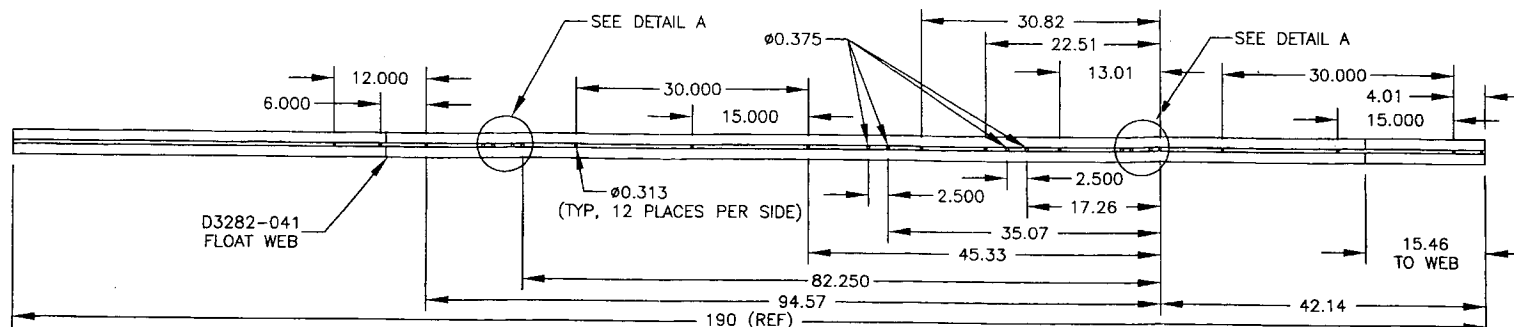
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

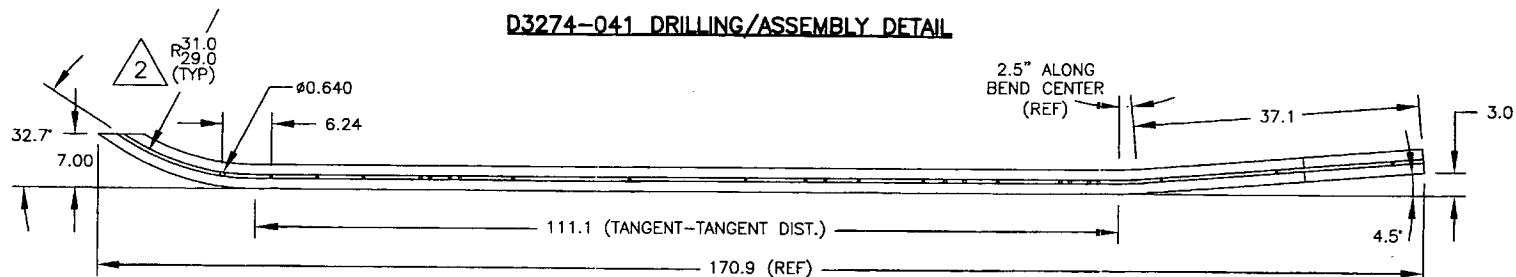
**NOTE:** Date & initial all entries



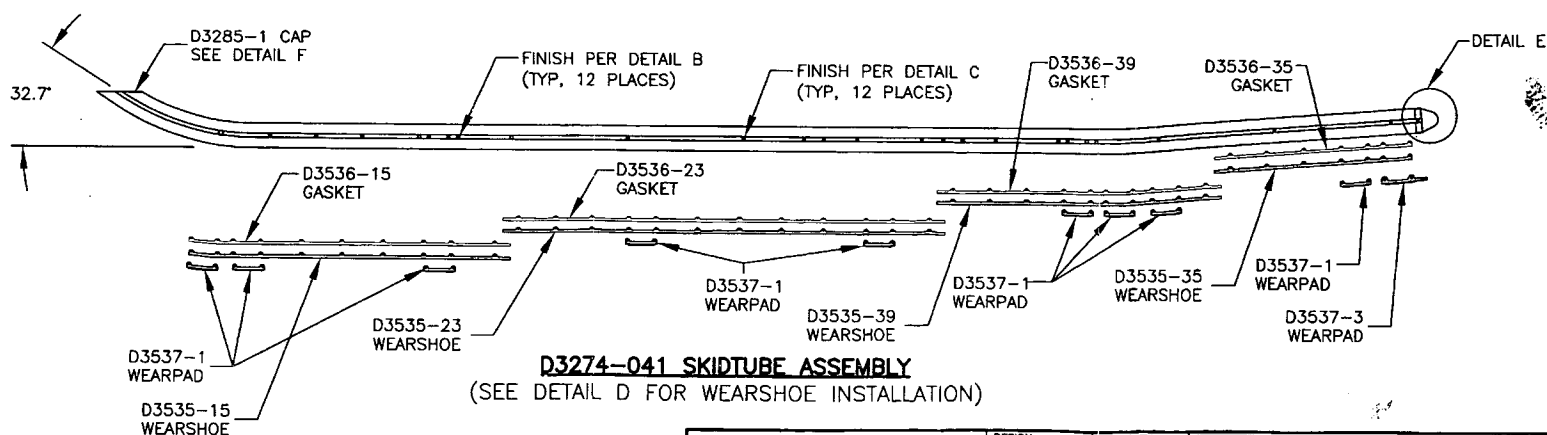
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



RELEASED

07.02.12

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DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	
DATE	06.12.19	DRAWING NO.	D3274	REV. D
TITLE			SKIDTUBE ASSEMBLY	SHEET 2 OF 4
				SCALE 1:15

85822

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

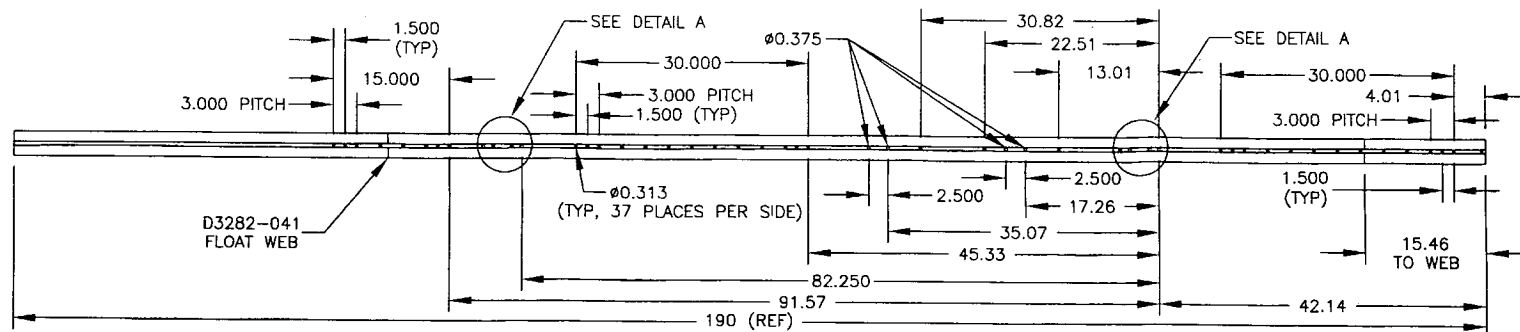
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

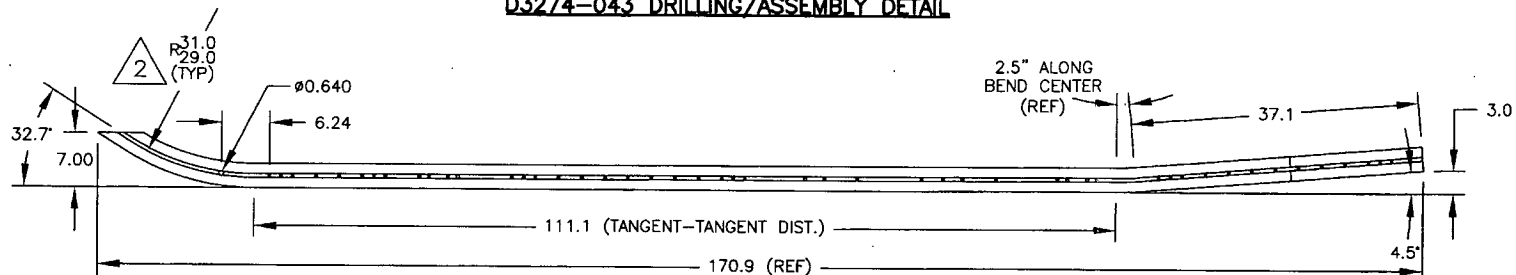
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

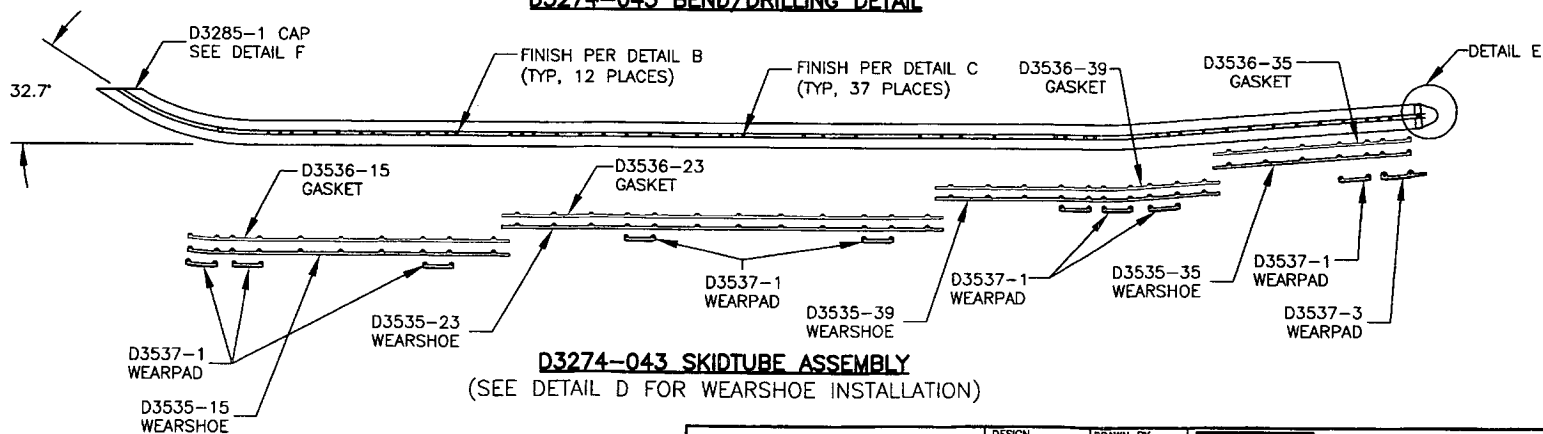
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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CHECKED	APPROVED	DATE	DRAWING NO.	REV. D
#	#	06.12.19	D3274	SHEET 3 OF 4
			TITLE	SCALE
			SKIDTUBE ASSEMBLY	1:15

05822

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

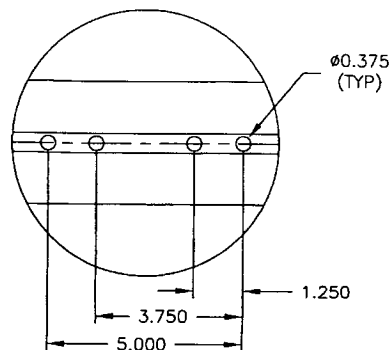
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

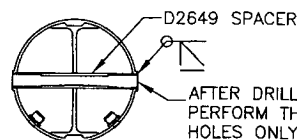
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DETAIL A: DRILL DETAIL

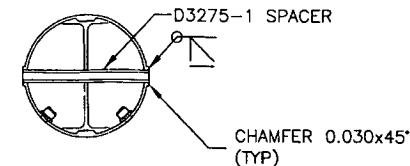


# DETAIL B FOR 0.375 HOLES ONLY

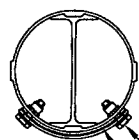


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# DETAIL C FOR 0.313 HOLES ONLY

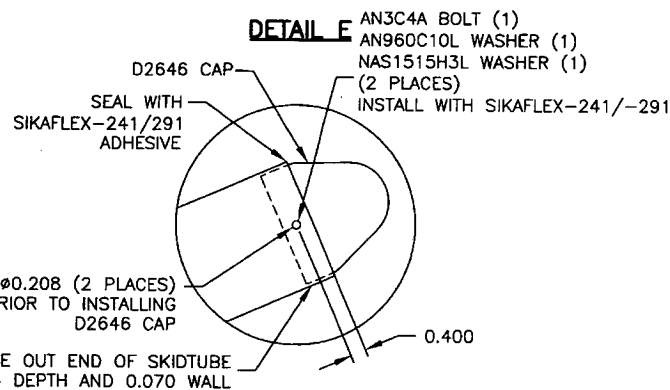


# DETAIL D

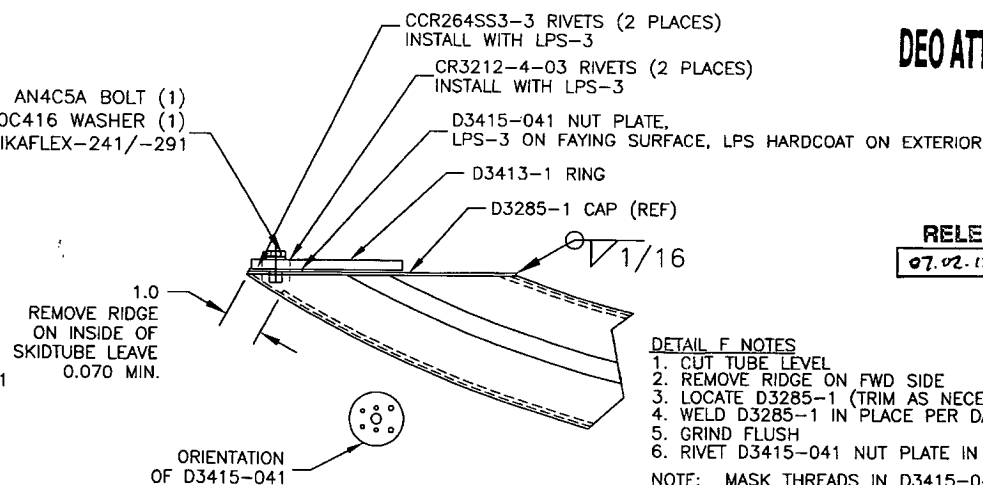


- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)  
GASKET/WEARSHOE/WEARPAD (REF)

# DETAIL E



# DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED  
07.02.12

- DETAIL F NOTES
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

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		DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY		SCALE 1:3

05022

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

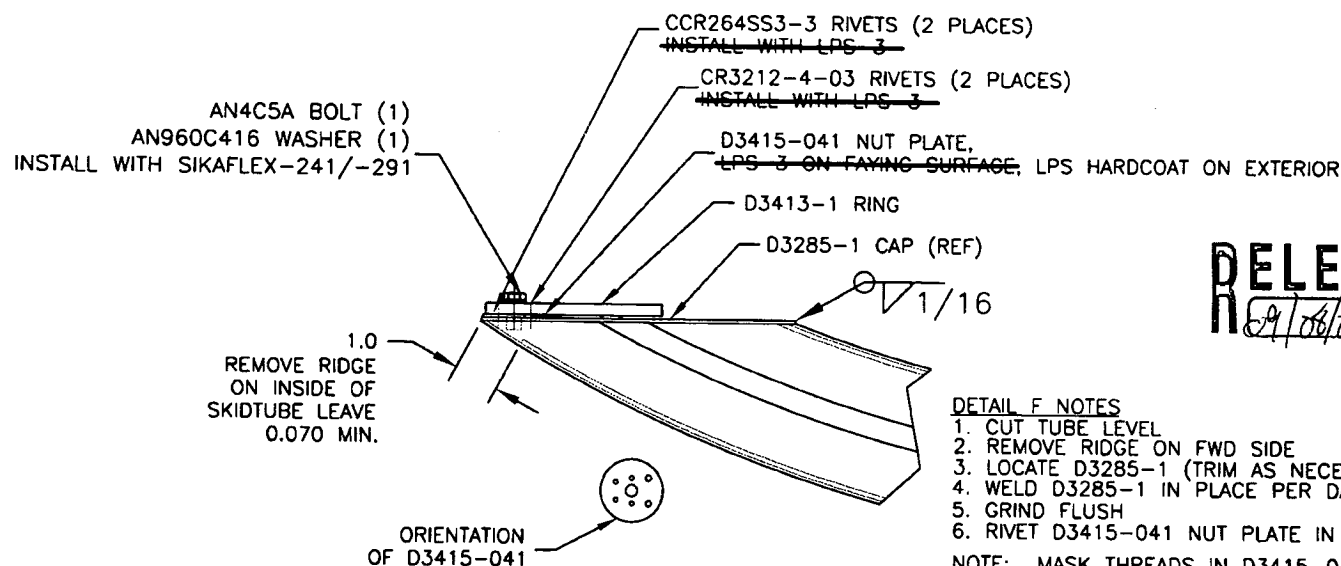
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

85822

### DETAIL F: END FINISHING DETAIL



**RELEASED**  
09/06/23

- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 297

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job #: 80951  
Part #: A206-642-151  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Penetration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Fusion:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Cracks:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Burn through:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

Qualifier [Signature] Date of Test Coupon 12.06.13

Welder [Signature] Date of Test Coupon 12.06.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld